

52

Date: Monday, 12/17/2007 1:09:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE
 Job Number : 36382
 Estimate Number : 10973
 P.O. Number :
 This Issue : 12/17/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D206667203
 First Issue : 1 / Type : LANDING GEAR Drawing Number : D206-667-243 REV B
 Previous Run : 36381 Drawing Revision : B
 Material :
 Due Date : 12/24/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07.12.17
 Comment : Est Rev: P 05.09.01 Add holes for compatibility with Bell
 Skidtubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



KS 07.12.19

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

J 0062/04

2.0

D6004115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6004-115

Crosstube

B32305

Check OD = 2.500"; ID = 1.800"

2P 08/01/03

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

SF 08/01/05

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SF 08/01/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L AFT X-TUBE

Job Number: 36382

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

S.F 08/01/05

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

S.F 08/01/05

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.F 08/01/05

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



AWM 08-01-07



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8-1-7

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM 08-01-07



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

12 8-1-7

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L AFT X-TUBE

Job Number: 36382

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

08-01-08 (1)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243.

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

ANM 08-01-09

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



ANM 08-01-09



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/01/11 (1)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/11 (1)

W/O:		WORK ORDER CHANGES					
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Job Number: 36382

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5434

08/01/14 ①

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

08/01/11 ①

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

08/01/11 (X) ①

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

08-01-13

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

08/01/14 ①

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-045

Nut Plate

34077

08-02-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L AFT X-TUBE

Job Number: 36382

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

36064

RT 08-02-01

24.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

105057

RT 08-02-01

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

RT 08-02-01

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

35900

RT 08-01-18

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support

34063

RT 08-01-18

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

105066

RT 08-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 36382

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

87 08-01-18

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-02-04 (1)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105408

R

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M105940

R

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M104246

R

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

R 8/21/4 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 8/02/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 206L AFT X-TUBE

Job Number: 36382

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-32A

Bolt M1005408

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer M106167

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location: C

PPP Rev: 8/2/4

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



min 2006/2/05

(1)

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36382
Description: Crosstube Assembly		Part Number:	D206-667-243
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

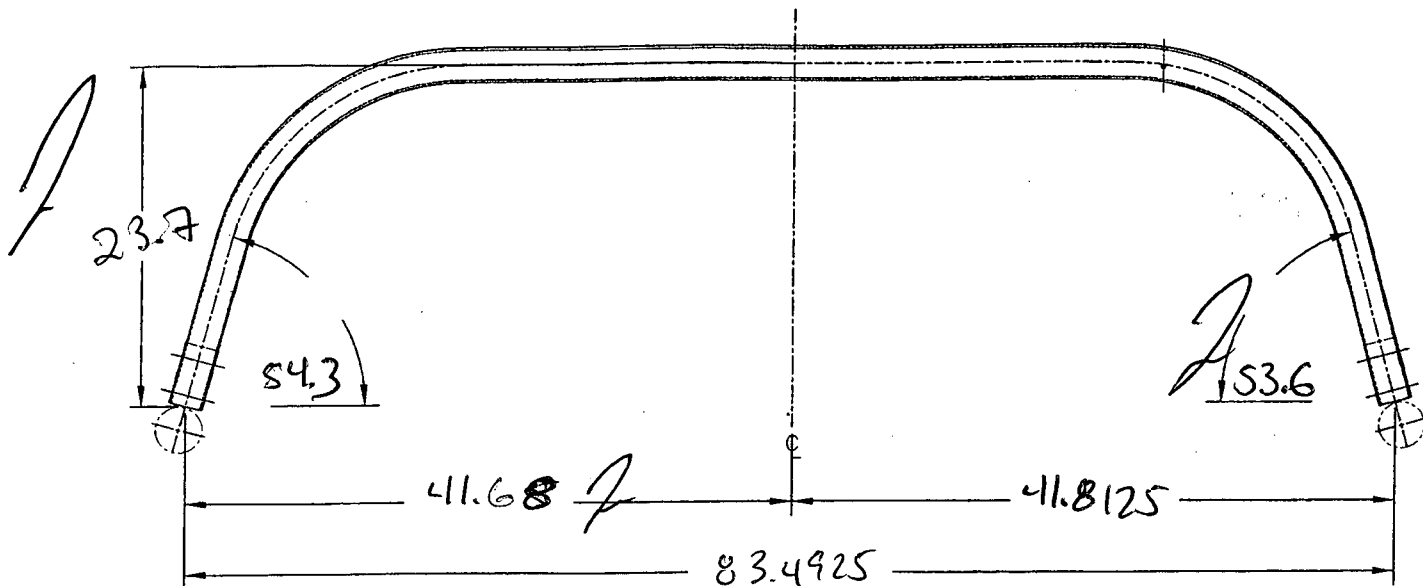
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.493	/			
	2.018	+0.005/-0.000	2.021	✓			
	2.079	+0.005/-0.000	2.081	✓			
	2.145	+0.005/-0.000	2.147	✓			
	2.209	+0.005/-0.000	2.211	✓			
	2.287	+0.005/-0.000	2.289	✓			
	2.363	+0.005/-0.000	2.363	✓			
	2.433	+0.005/-0.000	2.433	✓			
	0.200	+/-0.010	.200	✓			
	0.500 x 30°	+/-0.010	.500 x 30°	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.452	✓			
SIDE B	104.91	+/-0.020	104.91	✓			
	2.490	+0.005/-0.000	2.490	✓			
	2.018	+0.005/-0.000	2.020	✓			
	2.079	+0.005/-0.000	2.079	✓			
	2.145	+0.005/-0.000	2.145	✓			
	2.209	+0.005/-0.000	2.209	✓			
	2.287	+0.005/-0.000	2.287	✓			
	2.363	+0.005/-0.000	2.363	✓			
	2.433	+0.005/-0.000	2.433	✓			
	0.200	+/-0.010	.200	✓			
	0.500 x 30°	+/-0.010	.500 x 30°	✓			
	R0.063	+/-0.010	.063	✓			
	R0.500	+/-0.010	.500	✓			
	4.438	+/-0.030	4.441	✓			

Measured by:	J.F.	Audited by:	SR	Prototype Approval:	N/A
Date:	08/01/08	Date:	08-01-08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	

DART AEROSPACE LTD		Work Order:	36382
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments
Tube height is even, but tube is slightly overbent.
OKAY per 05/01/02

QC15 Inspection	05/01/02
Date	05/01/02

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 #

UNDER REVIEW

06.08.10 RH

re draw detail F

RH

07.05.02

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

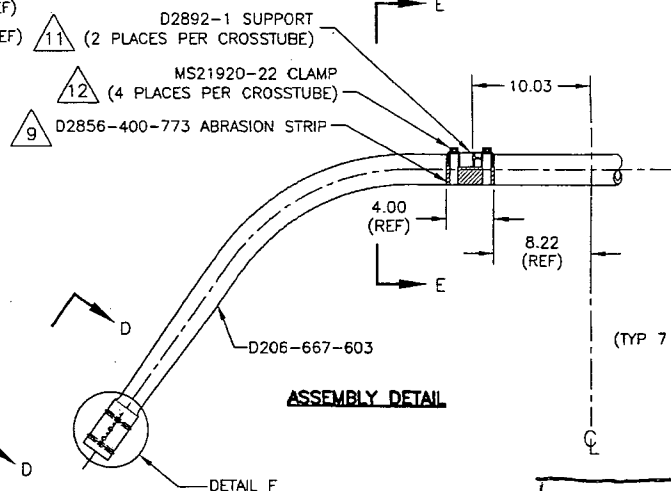
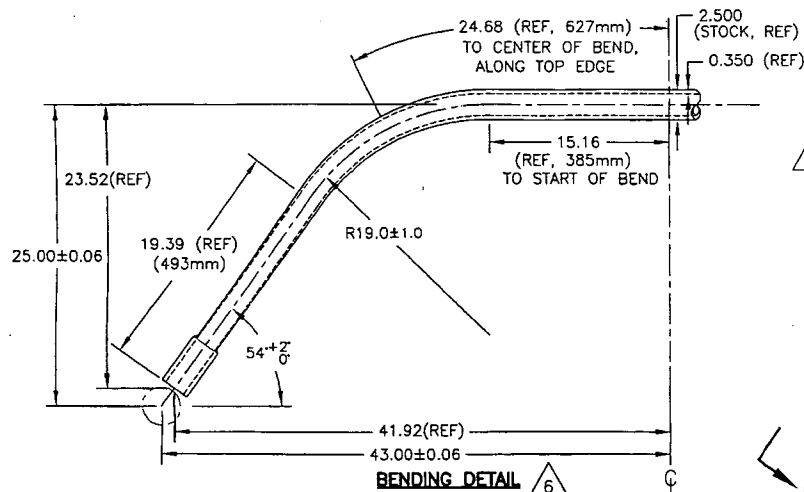
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36382

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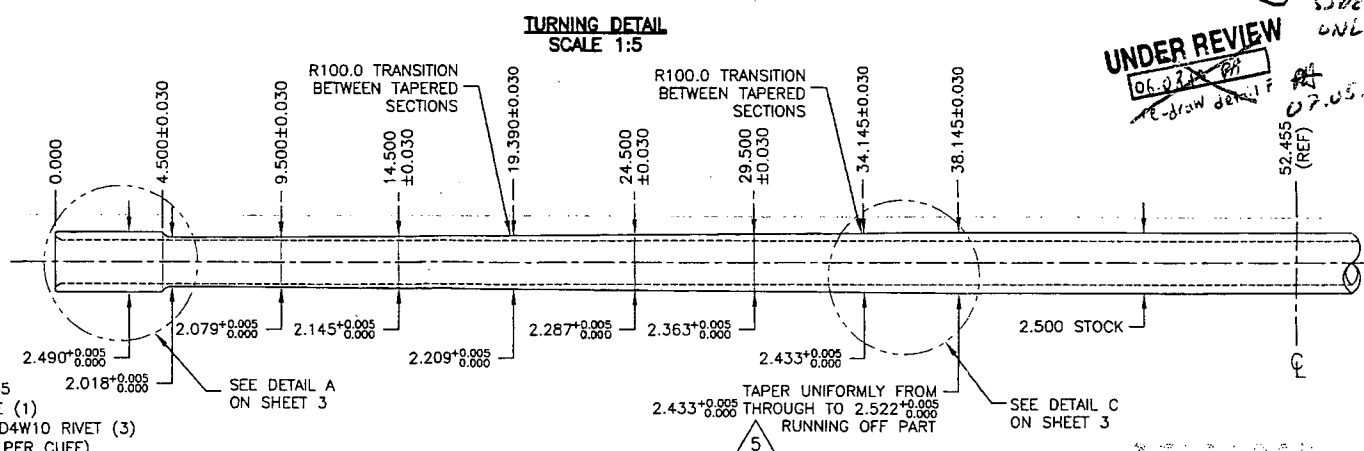
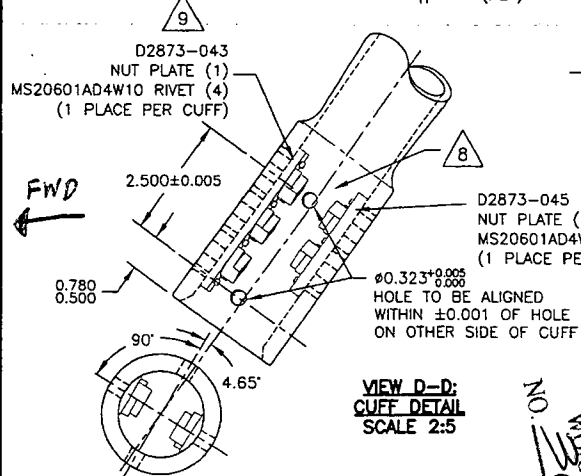
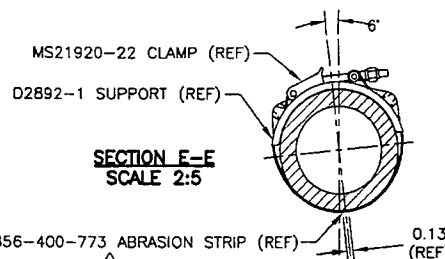
B $\varnothing 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\varnothing 0.128$
C'SINK $\varnothing 0.225 \times 1.00$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL E
SCALE 2:5

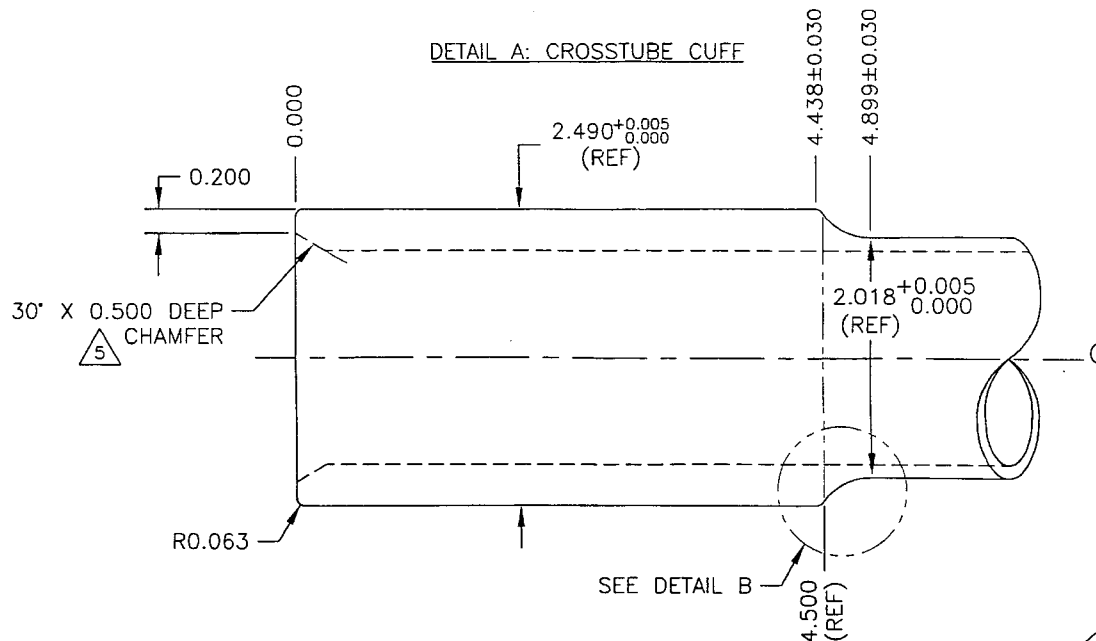
UNDER REVIEW
06.04.08
re-draw detail F
07.05.02



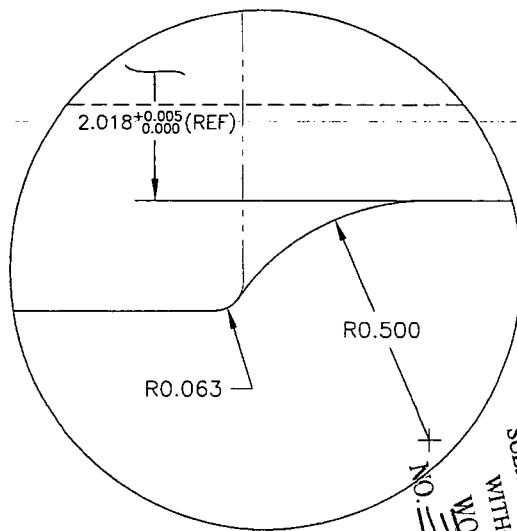
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		CHECKED	APPROVED	DRAWING NO.	REV. B
		DS	DS	D206-667-243	SHEET 2 OF 3
		DATE		TITLE	SCALE
		05.07.26		CROSSTUBE ASS'Y (206L HIGH AFT)	1:10

NO. 10382
WORK ORDER
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO ATTENDMENT
WITHOUT NOTICE

DETAIL A: CROSSTUBE CUFF

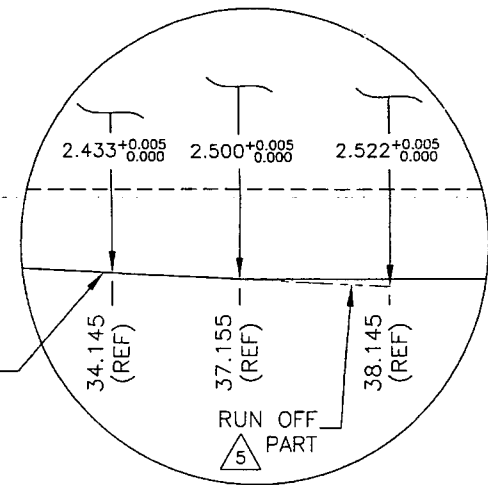


05.07.26 #
UNDER REVIEW
06.03.26 PH
Re-draw detail
PH 07.05.02



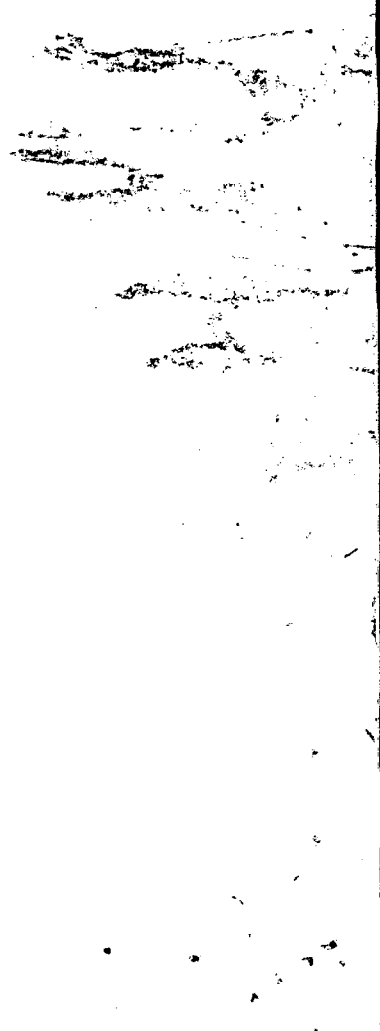
DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 36582
WORK ORDER
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		PH	PH		REV. B
		CHECKED DS	APPROVED DS	DRAWING NO. D206-667-243	SHEET 3 OF 3
		DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:1





LIQUID PENETRANT TEST REPORT

P - 8-1206

CLIENT	DART AREOSPACE	DATE	JAN. 11, 2008	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188-8-01206	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST. HAWKESBURY ONT.	POWOW NO.					
		WORK LOCATION	HAWKESBURY				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	HIGH AFT X-TUBE 412, 206B AFT X-TUBE, 206L FWD X-TUBE, 206L AFT X-TUBE						
ITEM(S) EXAMINED	JOBS #36061, 36062, 36371, 36372, 36374, 36375, 36376, 36378, 36380, 36382						

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE NO. LT-0002-02	REV./DATE
Part No.	D206667201, D206667103, D412664203, D206667203		Material	ALODYNED ALUMINUM
Thickness				
Scope	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.			

TEST DETAILS

Method	<input checked="" type="checkbox"/> Fluorescent	<input type="checkbox"/> Visible	<input checked="" type="checkbox"/> Water Wash	<input type="checkbox"/> Solvent Removable	<input type="checkbox"/> Post Emulsified
Family Brand	MAGNAFLUX		Black Light S/N	8178	<input checked="" type="checkbox"/> Output > 1000 μ W/cm ²
Penetrant	ZL67	Minimum Dwell time	45	Min.	<input checked="" type="checkbox"/> Ambient < 2 fc
Penetrant Remover	H20	Minimum Dry time	>10	Min.	<input checked="" type="checkbox"/> Output > 100 fc @ surface
Developer	SKDS2	Minimum Dwell time	10	Min.	Other
Developer Type	<input checked="" type="checkbox"/> Non Aqueous	<input type="checkbox"/> Aqueous	<input type="checkbox"/> Dry	Light Meter S/N	Cal Due Date
					MAR 08

TEST SURFACE

Surface Condition	<input checked="" type="checkbox"/> As Ground	<input type="checkbox"/> As Welded	<input checked="" type="checkbox"/> Machined	<input type="checkbox"/> Shot Blasted	<input type="checkbox"/> Clean Bare Metal
Surface Temperature	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F to 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☐ IMPERIAL)

item	Comments	Accept	Reject
Job #	36061: ACCEPTABLE		
	36062: ACCEPTABLE		
	36371: ACCEPTABLE		
	36372: ACCEPTABLE		
	36374: ACCEPTABLE		
	36375: ACCEPTABLE		
	36376: ACCEPTABLE		
	36378: ACCEPTABLE		
	36380: ACCEPTABLE		
	36382: ACCEPTABLE		

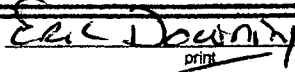

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

Client Representative		DTR #
Technician (Signature):		Report Reviewed by:
Name (Print):	FREDERICK CHAGNON	Name initials
	1 st technician	
CGSB Level	II	SNT Level
CGSB Reg. No	10560	CGSB Reg. No

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